Work Orde		3088		*1030)ጸጸ*			-			Page 1	
Revision ID:	D3027-3			Accept	*N900	<u>040</u>	100)* 5	Setup Sta	i Vi	S1* S2*	
Start Date: Required Date: Reference:	6/11/13 6/11/13	Start Qty: 10.00 Req'd Qty: 10.00	*1 0 * *1 0 *		Cust Item I	ID:						
Approvals:	Process Pla	an:	Date://S-Ole-19	Tooling: SPC (Y/N):		ate:		i	Run Sta Sto	1/1	R1* R2*	
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr D3027 110 *110* Waterjet FLOW CNC Waterjet 2024 - 0 50	Re	HAAS CNC VERTICAL Memo CUT AS PE DWG REV PROG REV	er dwg	0.00				10			Jm13-07.	· ఎ ¹
*120 *120* QC		DEBURR QC2- Inspect parts off n Memo	nachine FAI/FAIB	0.00				<u>10</u>	٥		Jn3-07-2	5

Quality Control

DQA:			Date:		· · · · · ·								TDART
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= .						DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
Work Orde	er: _						ı						
						Rework			Skid-tube	Crosstube	_	Water Jet	Engineering
Part N	۷o. <u>-</u>		<u> </u>			Scrap			Machining	Small Fab	⊣	d. Eng. Coor.	Quality
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Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
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		Cuffs			<u> </u>	Contamination	_	4	ions Incomplete/l	Jnclear	Part Moved		Wrong Stock Pulled
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QA Closed:			Date:			WORK ORDER NON-		JINFUI	RIVIAINCE / OI		/ork Order up	odate only	AEROSPACE
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Work Ord June-12-13 9:2			D 3 U 2 7 - 3 B 1 9 3 0 8 8		3088*					Page 3
tem ID: Revision ID: Item Name:	D3027-3			Accept	*N900	0401	וחח	* s	etup Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	6/11/13 : 6/11/13	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item I Customer:	ID:				
Approvals:		lan:	Date:	_	-	ate:		R	un Start Stop	*NR1* *NR2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty		Reject Insp. Number Stamp
*160 *160* HandFinish Hand Finishing		Chemical Conversion Coat Memo	t per QS1005 4,1	0.00	! ! !			.10_	THE S	<u> 13.7.31</u>
¹⁷⁰ *17∩*		QC7-Inspect Chemical Con	nversion Coat	0.00	·			(D)	73-08	Ob 80
QC Quality Control	ن پ	Memo		0.00	,			,	_0_00	OS47
180 *180* Packaging Packaging		Identify as per dwg & Stoc (Memo	ck Location: <u>570</u> 24	0.00				_ <i>l0</i> .x		1. W. 13-08-

DQA:		Date:			144004 00050 1401							"DART
QA Closed:		Date:			WORK ORDER NON-	-CC	JNFOI	RIMANCE / UI		Vork Order up	odate only	AEROSPACE
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Work Orde	er:									·- -	·	,
				i	Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	10				Scrap			Machining	Small Fab		d. Eng. Coor.	Quality
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ļ	Cracks				Broken/Damage/Defect	L	Hardwa	re		Part Incorred	ct	Temperature/Cure
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Work Ord June-12-13 9:		03088		*103	NA8*		Page 4
Item ID: Revision ID: Item Name:	D3027-3 Clip			Accept	*N90004010		art *NS1* top *NS2*
Start Date: Required Date Reference:	6/11/13 e: 6/11/13	Start Qty: 10.00 Req'd Qty: 10.00	*10' *10'		Cust Item ID: Customer:		
Approvals:	Process P	lan:	Date:	Tooling: _ SPC (Y/N):	Date:		*NR1* *NR2*
Sequence ID/ Work Center 190 *190* QC Quality Control	ID	Operation Description QC21- Final Inspection - Memo	Work Order Release	Set Up/ Run Hours 0.00	Tool ID Tool # Plan	-	Number Stamp

DQA:			Date:			WORK ORDER NON	~	ONICOI	DRAANCE / HDDATE				TDART
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Part N	-					Rework Scrap		1	Skid-tube Crosstube Machining Small Fall		-	Water Jet d. Eng. Coor.	Engineering Quality Other
NCR N	۱o.		•			Use-as-is Suspected Unapproved		rnerr	noforming Finishing Large Fab Composite		, Kec/sto	re/Packaging Supplier	J Other
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		Turning S				Finish		Out of	Calibration				
	Г	Wave/Tw				Fit/Function			Sequence				

Picklist Print Page 1 June-12-13 9:26:46 AM 103088 Work Order ID: **Start Date: 6/11/13** Required Date: 6/11/13 D3027-3 Parent Item: **Start Qty: 10.00** Required Qty: 10.00 Clip Parent Item Name: 1PP B01.09.27Now goes on HAASSM IPP REV:C NOW ON Comments: WATERJET JLM VERIFIED BY:EC Qty on Qty per Kit Total Component Item ID/ Replacement Mfg/ Bin Last Unit of Qty Date Status Primary Route Measure Hand Item Name Item ID Location Location Seq ID Qty Issued Issued Purch ltem 100 179.1920 0.0312 -0.328421 M2024T3S.050 No şſ Purchased 7m13-07-25 حـد٥ 2024-T3 .050 sheet Loc Oty Location Loc Code 179.192 **MAT022** 124643 124643 179,192

DQA:			Date:											DT
QA Closed:			Date:			WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE	\A/-	ork Order ur	ndata only	AEROS	SPACE
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	-					Use-as-is	1	Therr	moforming Finishing	<u>,</u>	Rec/Sto	re/Packaging	Othe	r
NCR I	No.					Suspected Unapproved]		Large Fab Composite			Supplier		
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	$\boldsymbol{\vdash}$	Crushing			<u> </u>	Countersink	\vdash	1	gned/off center	 	Positioned V	L Vrong		Jiicu
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	${f -}$	Inspection		Tube		Drawing		Misread		<u> </u>]. 5446, 25337.	B	- Conc.	
	$\boldsymbol{\vdash}$	Marks/Ch	·		-	Drill Holes	\vdash	Off-set						
	\vdash	Turning S				Finish	\vdash	ł	Calibration					-
	$\boldsymbol{\vdash}$	Wave/Tw	•	e		Fit/Function		4	Sequence					

DART AEROSPACE LTD	Work Order:	103088
Description: Clip	Part Number:	D3027-3
Inspection Dwg: D3027 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.500	+/-0.010	2.505	_		V	Jamos
0.375	+/-0.005	0.373	_		V	
1.050	+/-0.010	1.052			ν	
R0.13	+/-0.030	0.13"			RG	
1.880	+/-0.005	1.8%	_		_ ν	
0.940	+/-0.005	0.941	-		ν	
0.310	+/-0.005	0.313	_		V	
Ø0.098	+0.005/-0.000	0.098	-		V	
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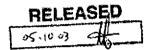
Measured by:	Audited by:	2.6	Prototype Approval:	N/A
Date: 13-07-25	Date:	137.26	Date:	N/A

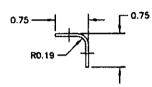
Rev	Date	Change		Revised by	Approved
Α	05.04.26	New Issue	P/O D350-689-013	KJ/JLM 1	21
В	06.03.09	Dwg Rev upated		KJ/JLM OK	<i>SM</i>

			·	

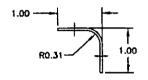


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CHECI	ŒD "	APPROVED 4/	DRAWING NO.	REV. B
	ALT.	-fit	D3027 SHEET	1 OF 2
DATE			TITLE	SCALE
05.0	9.20		CLIP	1:2
Α		01.05.18	NEW ISSUE	
æ		05.09.20	REMOVE HOLES FROM -7	

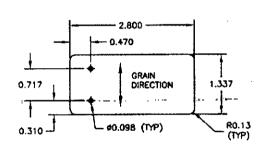




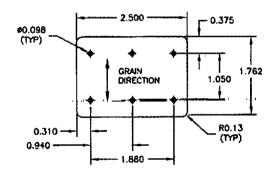
D3027-1 BEND DETAIL



D3027-3 BEND DETAIL



03027-1 FLAT PATTERN (0.063" SHEET)



D3027-3 FLAT PATTERN (0.050" SHEET)

103085 2113.05

NOTES:

- 1) BREAK ALL UNMARKED SHARP CORNER 0.010 TO 0.020
- 2) MATERIAL: 2024-T3 (QQ-A-250/4)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

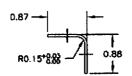
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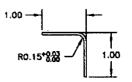


DESIGN RF	DRAWN BY		ROSPACE LTD Y, ONTARIO, CANADA
CHECKED A	APPROVED AM	DRAWING NO.	REV. B
#	#	D3027	SHEET 2 OF 2
DATE		TITLE	SCALE
05.09.20		CLIP	1:2

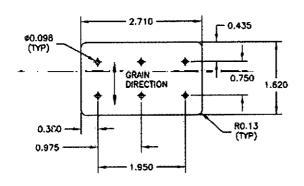
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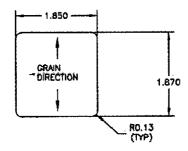
03027-5 BEND DETAIL



03027-7 BEND DETAIL



0.050" SHEET)



0.050" SHEET)

1305

NOTES:

- 1) BREAK ALL UNMARKED SHARP CORNER 0.010 TO 0.020
- 2) MATERIAL: 2024-T3 (QQ-A-250/4)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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